

Date: Tuesday, 08/01/2008 3:19:44 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35582 -2
Estimate Number : 10387
P.O. Number :
This Issue : 08/01/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 06/11/2007 Type : MACHINED PARTS
Previous Run : 35478

Drawing Name : 03.250 SUPPORT
Part Number : D29401
Drawing Number : D2940 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 13/12/2007

Written By :
Checked & Approved By :
Comment : Est. C 02.11.26 Reformat; Added P/O KJ
Est Rev:D Added priming as per Rev B 07-04-30 JLM

Qty: 20 Um: Eac

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6104007	17-4 SS Roundbar 4.50"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
17-4 SS Roundbar 4.50"OD
D6104-007
BATCH: 35582A

2.0	35582A	ROUND BILLET 17-4
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Comment: Sub-Component ROUND BILLET 17-4
D6104-007 B

3.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan
Turn blank for Haas as per Folio FA079

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS
1- Machine as per Folio FA079
2- Tumble & Deburr

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 35582

Part Number: D29401

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET <i>mk / 29/3.1 08/04/09</i> 16 (8)		
7.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>mk / 29.04-09</i> 16 (8)		
8.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 *****Mask Inside Surface as per Dwg D2940***** <i>M 107550</i> <i>mk</i> 16 (8X) 08/04/11		
9.0	SPRAY PAINTING	SPRAY PAINTING
Comment: SPRAY PAINTING <i>mk</i> 08 04 14 16 (8) (16) Prime inside surface as per Dwg D2940 and QSI 005 4.3.		
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>mk</i> 08 - 04 - 15 16 (16)		
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>LG</i> <i>mk</i> 08 04 15 16 (8) 16		
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE <i>mk</i> 08/04/16 16		
Job Completion		<i>mk</i> 08-04-16

AEROSPACE LTD		Work Order:	35582
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.726	.726	.724	.724		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.150	.150	.150	.150		
AD	3.510	3.530		3.514	3.525	3.523	3.523		
AE	1.633	1.673		1.647	1.656	1.656	1.656		
AF	1.493	1.513		1.497	1.502	1.500	1.500		
AG	0.040	0.060		.051	.050	.050	.050		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.148	.153	.153	.153		
AJ	2.518	2.538		2.530	2.530	2.530	2.530		
AK	0.040	0.060		.051	.051	.053	.053		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.154	.154	.152	.152		
AN	0.350	0.450		.355	.355	.355	.355		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.150	.154	.155	.155		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.266	.266	.266		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.123	4.126	4.127	4.126		
AV									
Accept/Reject									

Measured by:	AP / JLM
Date:	01/12/18

Audited by:	AP
Date:	08.01.06

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	AP

AEROSPACE LTD		Work Order: 35582
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.955	4.956	4.955		
C	0.718	0.738		0.725	0.725	0.72	0.725		
D	0.090	0.110		0.103	0.102	0.102	0.103		
E	3.564	3.584		3.574	3.574	3.579	3.579		
F	0.022	0.042		0.03	0.03	0.03	0.03		
G	3.444	3.464		3.454	3.454	3.455	3.455		
H	0.112	0.132		0.12	0.12	0.12	0.12		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.46		
K	0.413	0.433		0.422	0.423	0.422	0.422		
L	0.913	0.933		0.923	0.923	0.923	0.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by: [Signature]	Audited by: [Signature]
Date: 06/12	Date: 08-04-09

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	[Signature]

AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/9	2/10	3/11	4/12	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.732	.734	.725	.727		
D	0.090	0.110		.102	.102	.103	.102		
E	3.564	3.584		3.577	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.152	.151	.151	.151		
AD	3.510	3.530		3.522	3.522	3.524	3.523		
AE	1.633	1.673		1.664	1.659	1.656	1.655		
AF	1.493	1.513		1.506	1.504	1.502	1.498		
AG	0.040	0.060		.050	.053	.050	.051		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.152	.153	.146	.147		
AJ	2.518	2.538		2.530	2.530	2.536	2.530		
AK	0.040	0.060		.050	.051	.050	.049		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.149	.148	.148	.148		
AN	0.350	0.450		.360	.360	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.158	.155	.157	.156		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.124	4.124	4.127	4.127		
AV									
Accept/Reject									

Measured by:

Date:

 JL / 9/12
 08/04/08

Audited by:

Date:

2.01.09

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	BE

AEROSPACE LTD		Work Order:	3582
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1/3	2/4	3/5	4/6		
Lathe Section									
A	3.211	3.216							
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.724	.726	.727	.728		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.180	2.180	2.180	2.180		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.150	.149	.150	.151		
AD	3.510	3.530		3.525	3.525	3.527	3.525		
AE	1.633	1.673		1.655	1.657	1.657	1.655		
AF	1.493	1.513		1.497	1.500	1.497	1.498		
AG	0.040	0.060		.050	.050	.050	.050		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.148	.145	.146	.146		
AJ	2.518	2.538		2.528	2.527	2.528	2.528		
AK	0.040	0.060		.049	.050	.049	.052		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.146	.147	.146	.146		
AN	0.350	0.450		.360	.360	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.158	.158	.160	.158		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.266	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.128	4.128	4.128	4.128		
AV									

Accept/Reject

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 08/04/09	Date: 06-04-09

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	<i>[Signature]</i>

AT AEROSPACE LTD		Work Order: 35582
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

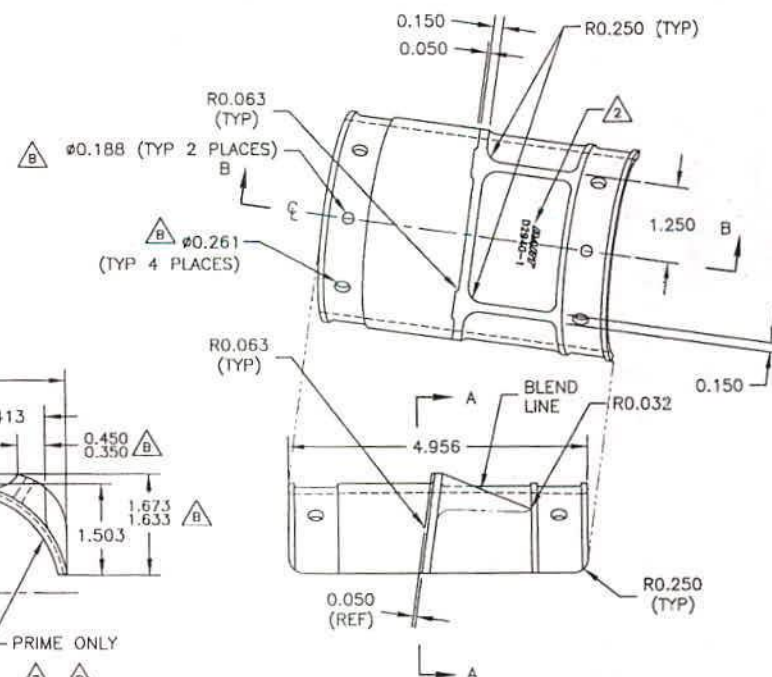
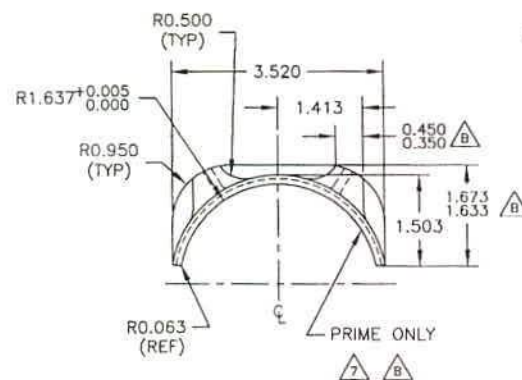
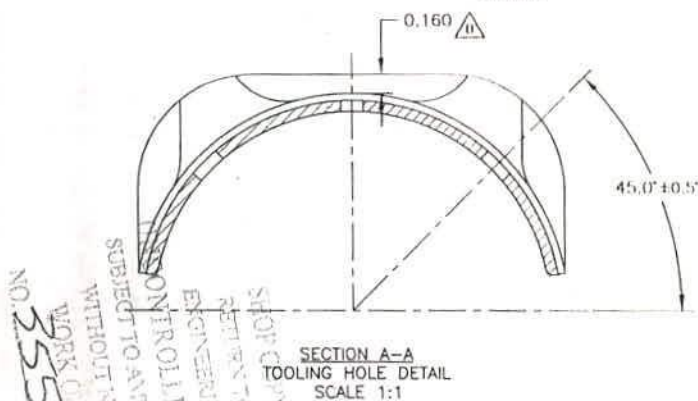
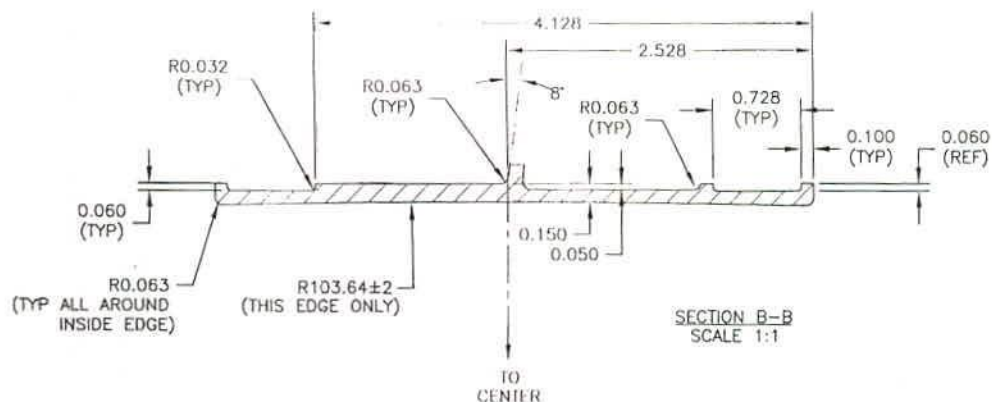
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	218	319	420		
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.955	4.955	4.955	4.955		
C	0.718	0.738		0.728	0.728	0.728	0.728		
D	0.090	0.110		0.102	0.102	0.102	0.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		0.03	0.03	0.03	0.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.122	0.122	0.122	0.122		
I	2.170	2.190		2.180	2.180	2.180	2.180		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		0.423	0.423	0.423	0.423		
L	0.913	0.933		0.923	0.923	0.923	0.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by: 20
Date: 23/02/18

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	EE

RELEASED
67-434 UP
PER ECR 187



- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

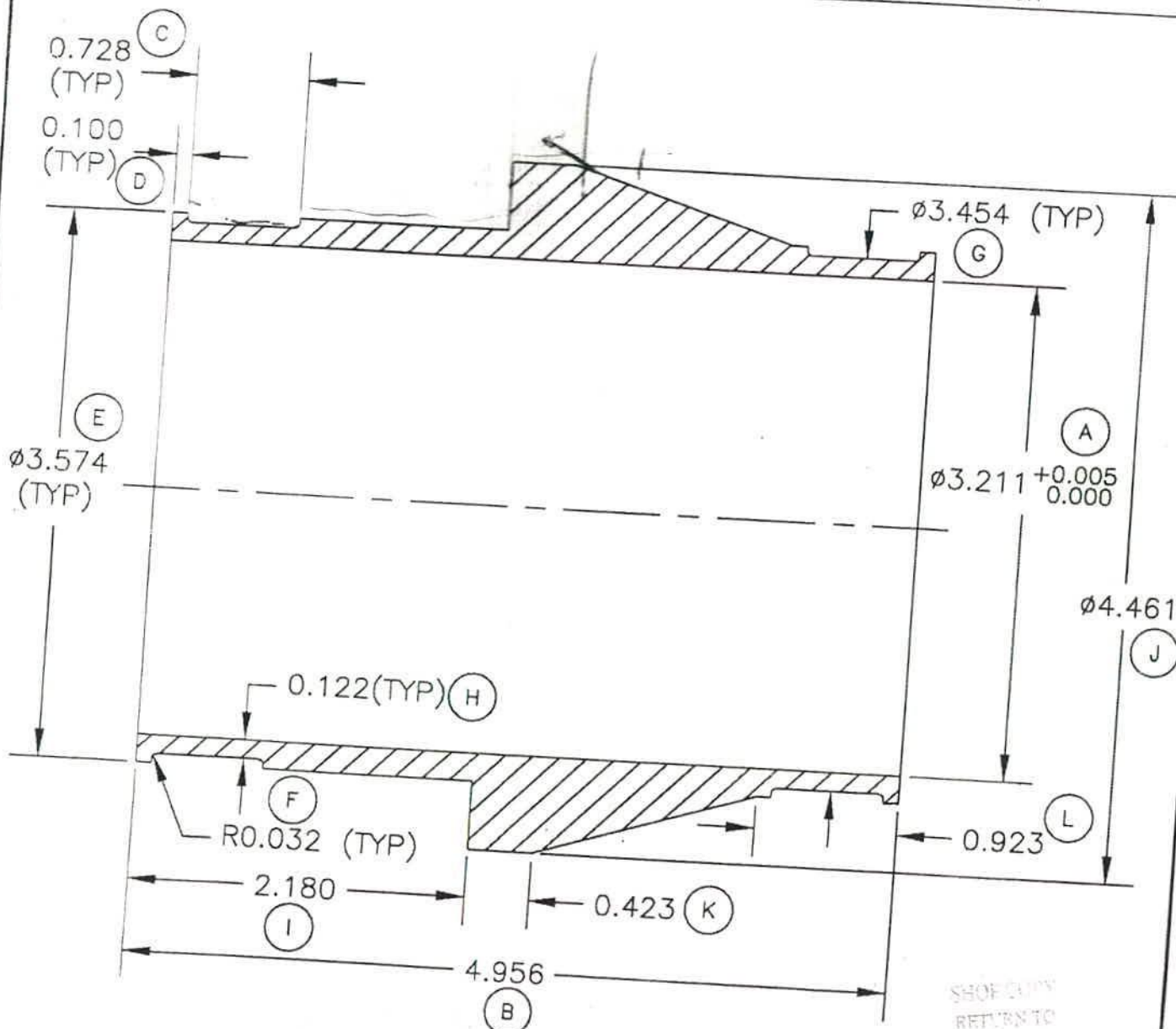
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DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	GP	DRAWN BY
CHECKED	TH	APPROVED
DATE	07.03.16	TITLE
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D2940
		REV. B SHEET 1 OF 1
		SCALE 1:2



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 081	REV. SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	



D2940-1 TURNING DETAIL

SHOE COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITH THE
WORK ORDER
NO. 35582